

# Work Order ID 86127

\*86127\*

Page 1

June-21-12 7:35:10 AM

Item ID: D3929-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Gusset Assembly

Start Date: 21/06/2012 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 27/06/2012 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/21 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3929

Rev A

100

0.00

\*100\*

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3929

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

6 0 Jm 12-6-23

6 0 Jm 12-6-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86127

**\*86127\***

Page 2

June-21-12 7:35:10 AM

Item ID: D3929-041

Accept

**\*N9000040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Gusset Assembly

Start Date: 21/06/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 27/06/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

6 N 12 06 24

140

0.00

**\*140\***

Large Fab

Memo

0.00

Large Fab

Weld bushings D3907-1 as per dwg D3929

316L rod batch: M171602

CC 12 - 6 - 26 (6H)

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*150\***

QC

Memo

0.00

Quality Control

6x 12.06.27

W/O:		WORK ORDER CHANGES					
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# Work Order ID 86127

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Page 3

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Item ID: D3929-041

Accept

**\*N9000040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Gusset Assembly

Start Date: 21/06/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 27/06/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

by PL 12.06.27

by PL 12.06.27

12/6/28 JD

Create custom w/o  
D3929-041 to  
pull 041  
onto #86380

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

June-21-12 7:40:23 AM

Page 1

Work Order ID: 86127

\*86127\*

Parent Item: D3929-041

\*D3929-041\*

Parent Item Name: Gusset Assembly

Start Date: 21/06/2012

Required Date: 27/06/2012

Start Qty: 6.00

Required Qty: 6.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

63.9260

0.45

2.842105

\*M304S11GA\*

304/316 0.125 Sheet

\*\*

Jun 12-6-23

### Location

### Loc Qty

### Loc Code

MAT020

63.926

121380

24.9

121780

39.026

120780

D3907-1

Manufactured

No

130

Each

39.0000

2

12

\*D3907-1\*

Bushing

\*\*

CC 12-6-26

### Location

### Loc Qty

### Loc Code

WA

39

82786

39

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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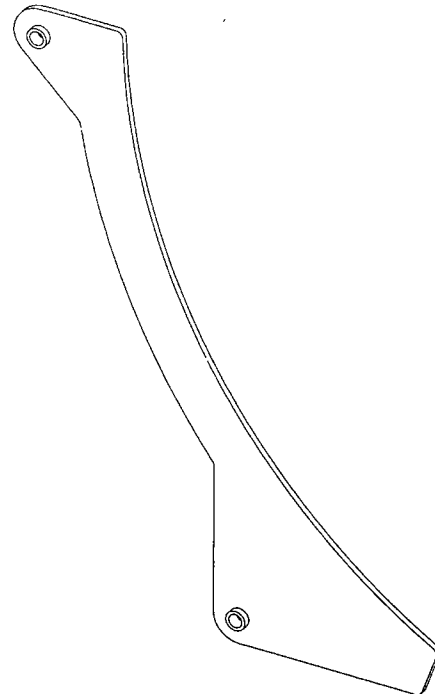
**NOTE:** Date & initial all entries

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET

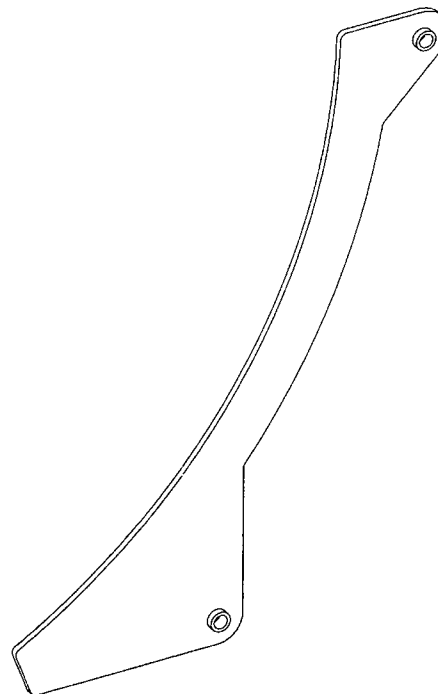
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 86127 MCT  
12/06/21



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

**RELEASED**  
8/64/21

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.73 lbs EACH
  - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	09.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.03		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3929** REV. A  
SHEET 1 OF 3

TITLE **GUSSET ASSEMBLY** SCALE NTS

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W/O:		WORK ORDER CHANGES					
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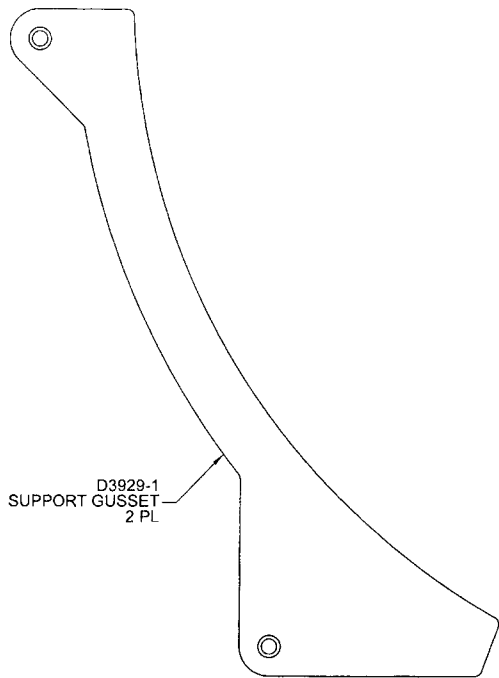
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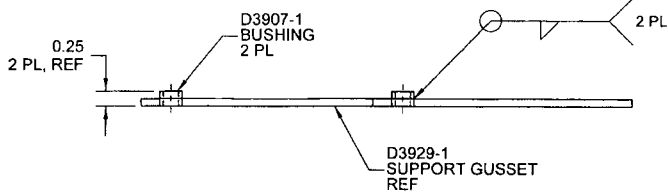
C

B

A

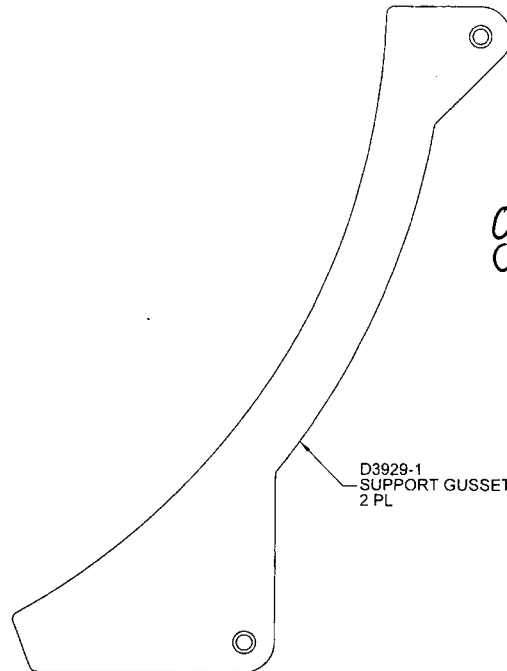


D3929-1  
SUPPORT GUSSET  
2 PL

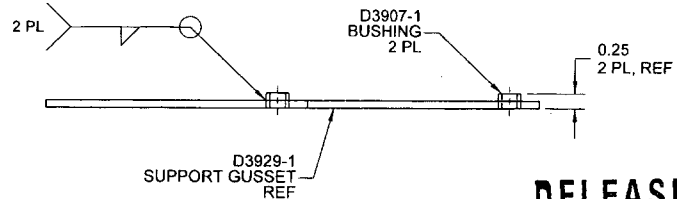


**D3929-041 GUSSET ASSEMBLY**

86127



D3929-1  
SUPPORT GUSSET  
2 PL



**D3929-042 GUSSET ASSEMBLY**

**RELEASED**  
09/04/22 MD

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3929</b>	REV. A
MFG. APPR.		SHEET 2 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		<b>GUSSET ASSEMBLY</b>	NTS
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8 7 6 5 4 3 2 1

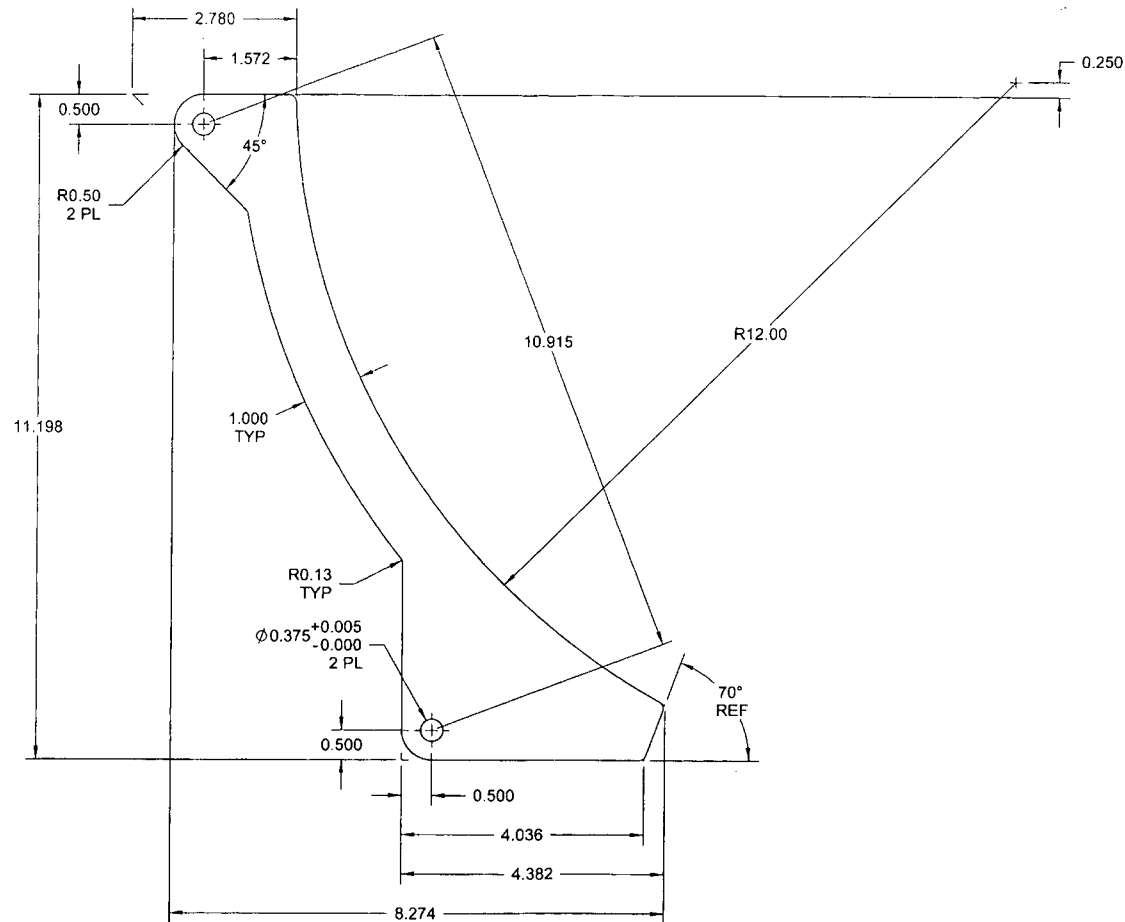
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**NOTE:** Date & initial all entries



**D3929-1 SUPPORT GUSSET**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
11 GAUGE (0.125 THICK)  
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
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